

Date: Friday, 25/04/2008 11:04:01 AM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: COVER
Job Number	: 38789		
Estimate Number	: 13273		
P.O. Number	:	Part Number	: D32023
This Issue	: 25/04/2008 S.O. No. :	Drawing Number	: D3202 REVC PRELIM
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 / Type : SMALL / MED FAB	Drawing Revision	: C PRELIM
Previous Run	:	Material	:
Written By	: <u>Jul 08-04-25</u>	Due Date	: 02/05/2008 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A new issue 08-04-21 DD verified by:EC		

Additional Product

FOR ENGINEERING USE ONLY

PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S032	5052-H32 .032 Sheet
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Comment: Qty.: 1.6286 sf(s)/Unit Total : 1.6286 sf(s)
5052-H32 .032 Sheet
Batch: 10753 IB 8-4-28

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3202
Dwg Rev: C IB 8-4-28
Prog Rev: C
2-Deburr if necessary IB 8-4-28

④

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Jul 08-04-29 ①

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

HD 08-05-09 RV

Date: Friday, 25/04/2008 11:04:01 AM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER

Job Number: 38789

Part Number: D32023

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M 105412



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

8:50AM

OVEN TEMPERATURE:

320°F

FINISH TIME:

9:20AM

91 08-05-05 (X)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

ENGINEERING

APPROVAL AS



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-05-05

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

2296

9.0

QC21

FINAL INSPECTION/W/O RELEASE



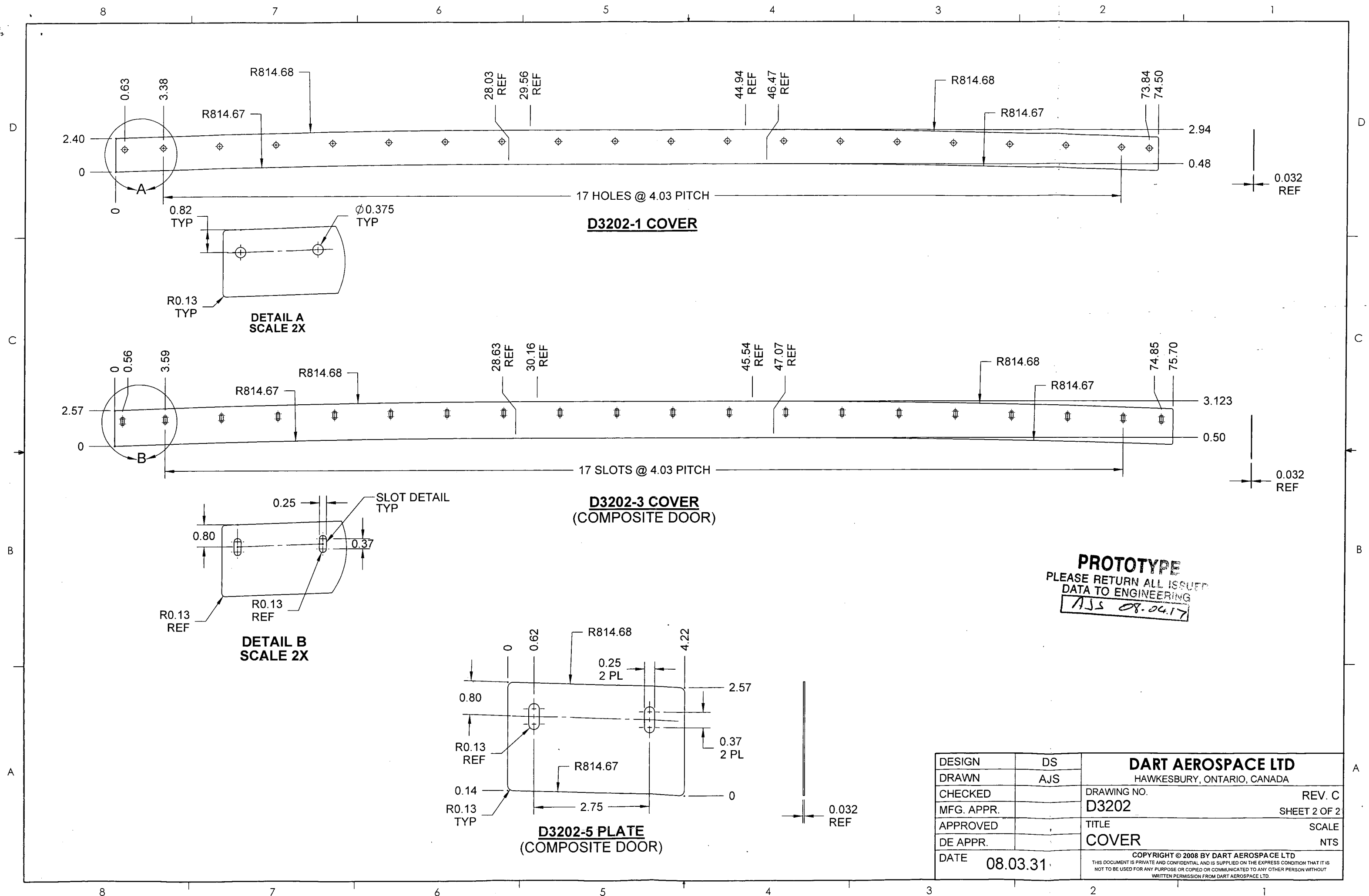
Comment: FINAL INSPECTION/W/O RELEASE

08/08/05

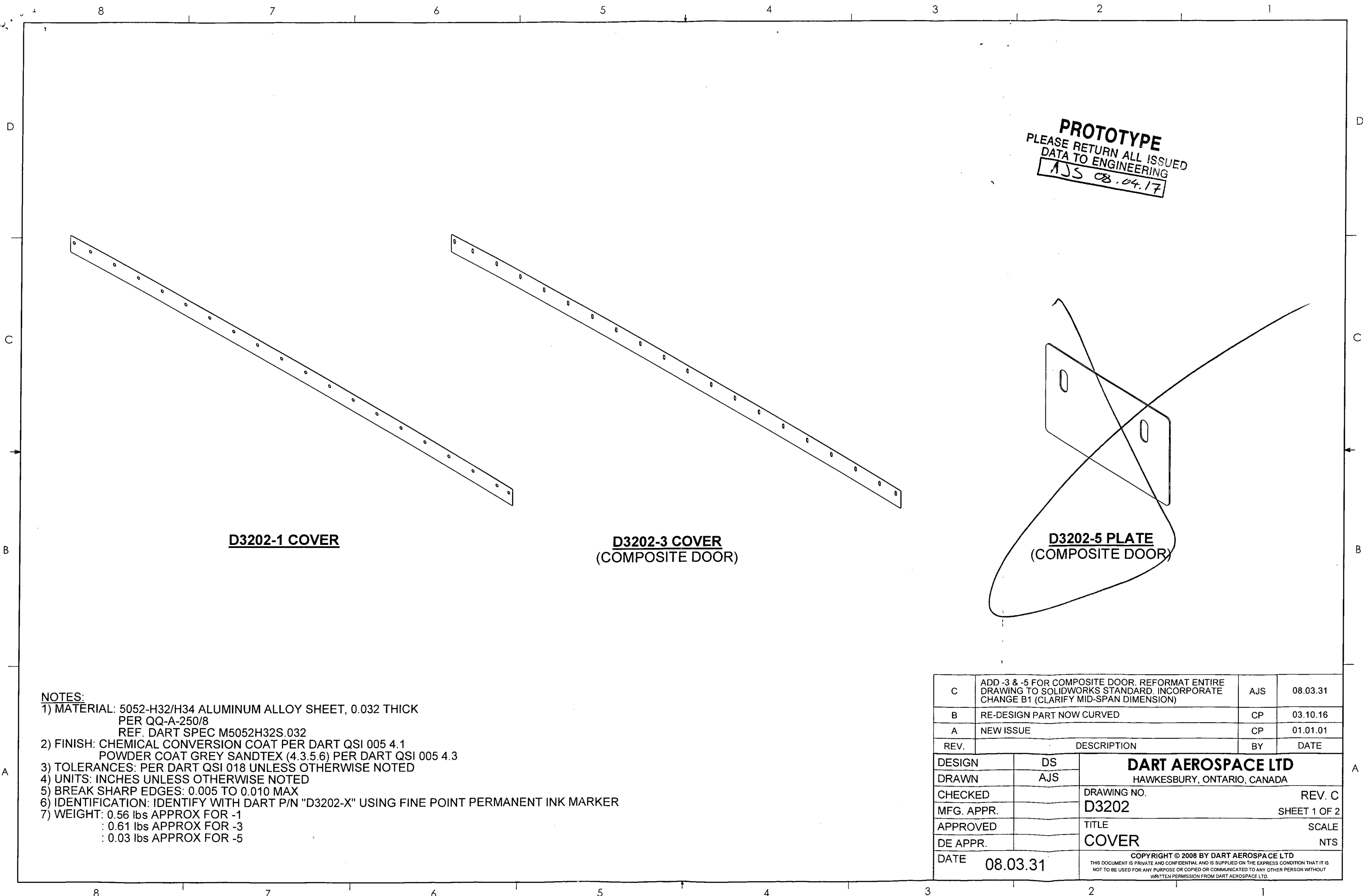
Job Completion



Change to w/o 00220 08/08/05



DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3202	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		COVER	NTS
DATE	08.03.31	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
AJS 08.04.17

D3202-1 COVER

D3202-3 COVER
(COMPOSITE DOOR)

D3202-5 PLATE
(COMPOSITE DOOR)

- NOTES:**
- 1) MATERIAL: 5052-H32/H34 ALUMINUM ALLOY SHEET, 0.032 THICK
PER QQ-A-250/8
REF. DART SPEC M5052H32S.032
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3202-X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.56 lbs APPROX FOR -1
: 0.61 lbs APPROX FOR -3
: 0.03 lbs APPROX FOR -5

C	ADD -3 & -5 FOR COMPOSITE DOOR. REFORMAT ENTIRE DRAWING TO SOLIDWORKS STANDARD. INCORPORATE CHANGE B1 (CLARIFY MID-SPAN DIMENSION)	AJS	08.03.31
B	RE-DESIGN PART NOW CURVED	CP	03.10.16
A	NEW ISSUE	CP	01.01.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3202	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		COVER	NTS
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